

Work Order ID 148789

July 08, 2016 10:33:35 AM

148789

Page 1

Item ID: PB67-43001-09

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 7/8/2016 Start Qty: 3.00

Required Date: 8/3/2016 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: SA Date: 7/12/16 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-09	D

100 Weld per dwg A/R Aluminum rod Batch: 134826 0.00
Large Fab

100

Large Fab

Large Fab

Memo

0.31

1- Assemble parts on jig DT8814 and weld as per dwg PB67-43001

** Ensure no burn thru after welding in tube -235 and -229 only where bushing -
265 ***

3 JUL 25 2016 DAS 24 9-89

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

JUL 18 2016 DAS 24 9-89

3 16-07-27

DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____	

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Setup Start

NS1

Revision ID:

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NS2

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 7/8/2016 Start Qty: 3.00

3

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Required Date: 8/3/2016 Req'd Qty: 3.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.01

Quality Control

⑤ 16-01-27

DAS
9
9-89

130

Green Sandtex(Ref:4.3.5.8) per OSI005 4.3

0.00

130

Powdercoat

Memo

0.08

Powder Coating

***MASK ALL OPENING AND INDICATED AREAS PRIOR TO
POWDERCOATING, SEE NOTE 9 SHEET 2-3****

START TIME: 9:15

OVEN TEMPERATURE: 300°

FINISH TIME: 9:45

3 16-07-28

DAS
38
9-89

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.01

Quality Control

③

DAS
38
9-89

JUL 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>MEZZ</i>	0.00				<i>3</i>	<i>JUL 28 2016</i>		<i>DAS 24 9-89</i>
150									
Packaging	Memo	0.01							
Packaging									
160	QC21 - Final Inspection - Work Order Release	0.00							<i>DAS 21 9-89</i>
160								<i>AUG 03 2016</i>	
QC	Memo	0.05							
Quality Control									

SU 7/28/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

July 08, 2016 10:33:34 AM

Page 1

Work Order ID: 148789

148789

Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP RevB
10.09.24 per revC dwg EC verified by:DD IPP REV:C 14.12.15
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-203W		Manufactured	No			100	Each	8.0000	1	3			
✓ *PR67-43001-203W*									**			JUL 25 2016	DAS 24 9-89
Square Tube Weldment													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MEZZ		8							
				139208		8				3			
PB67-43001-229W		Manufactured	No			100	Each	3.0000	1	3			
✓ *PR67-43001-229W*									**			JUL 25 2016	DAS 24 9-89
Outer Tube Weldment													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		3							
				139199		3				3			
PB67-43001-239W		Manufactured	No			100	Each	1.0000	1	3			
✓ *PR67-43001-239W*									**			JUL 25 2016	DAS 24 9-89
Square Tube Weldment													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WWA04		1							
				139197		1		B 148790		2			
PB67-43001-201		Manufactured	No			100	Each	10.0000	2	6			
✓ *PR67-43001-201*									**			JUL 25 2016	DAS 24 9-89
Square Tube													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		10							
				139209		10				6			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

Picklist Print

July 08, 2016 10:33:34 AM

Page 2

Work Order ID: 148789

148789

Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-209

Manufactured No

100

Each

6.0000

1

3

✓ ***PR67-43001-209***
Square Tube

**

JUL 25 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

6

139206

6

3

PB67-43001-211

Manufactured No

100

Each

42.0000

6

18

✓ ***PR67-43001-211***
Square Tube

**

JUL 25 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

42

139201

42

18

PB67-43001-213

Manufactured No

100

Each

9.0000

2

6

✓ ***PR67-43001-213***
Flanged Hook

**

JUL 25 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

9

112764

1

139200

8

6

PB67-43001-235

Manufactured No

100

Each

3.0000

1

3

✓ ***PR67-43001-235***
Outer Tube

**

JUL 25 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

3

139198

3

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-243

Manufactured No

100

Each

5.0000

1

3

DAS
24
9-89

PR67-43001-243

Tube Handle Extension

**

JUL 25 2016

Location

Loc Qty

Loc Code

Mezz2

5

133673

1

139196

4

100

Each

2.0000

1

3

DAS
24
9-89

PB67-43001-277

Manufactured No

PR67-43001-277

Contoured Male Eye

**

JUL 25 2016

Location

Loc Qty

Loc Code

Mezz2

2

133674

2

100

Each

8.0000

2

6

DAS
24
9-89

PB67-43001-311

Manufactured No

PR67-43001-311

Restraint

**

JUL 25 2016

Location

Loc Qty

Loc Code

Mezz

1

90935

1

Mezz2

7

139192

7

100

Each

6.0000

1

3

DAS
24
9-89

D3440-9

Manufactured No

D3440-9

Tube Detent Clip Base (Supersedes B67-43001-241)

**

JUL 25 2016

Location

Loc Qty

Loc Code

Mezz2

6

139210

6

3

DQA: _____ Date: _____



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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

Page 4

July 08, 2016 10:33:34 AM

Work Order ID: 148789

148789

Parent Item: PB67-43001-09

PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

D3440-13

Manufactured No

100

Each

6.0000

1

3

D3440-13

JUL 25 2016

DAS

Bracket (Supersedes B67-43001-273)

**24
9-00**

Location

Loc Qty

Loc Code

Mezz2

6

139211

6

3

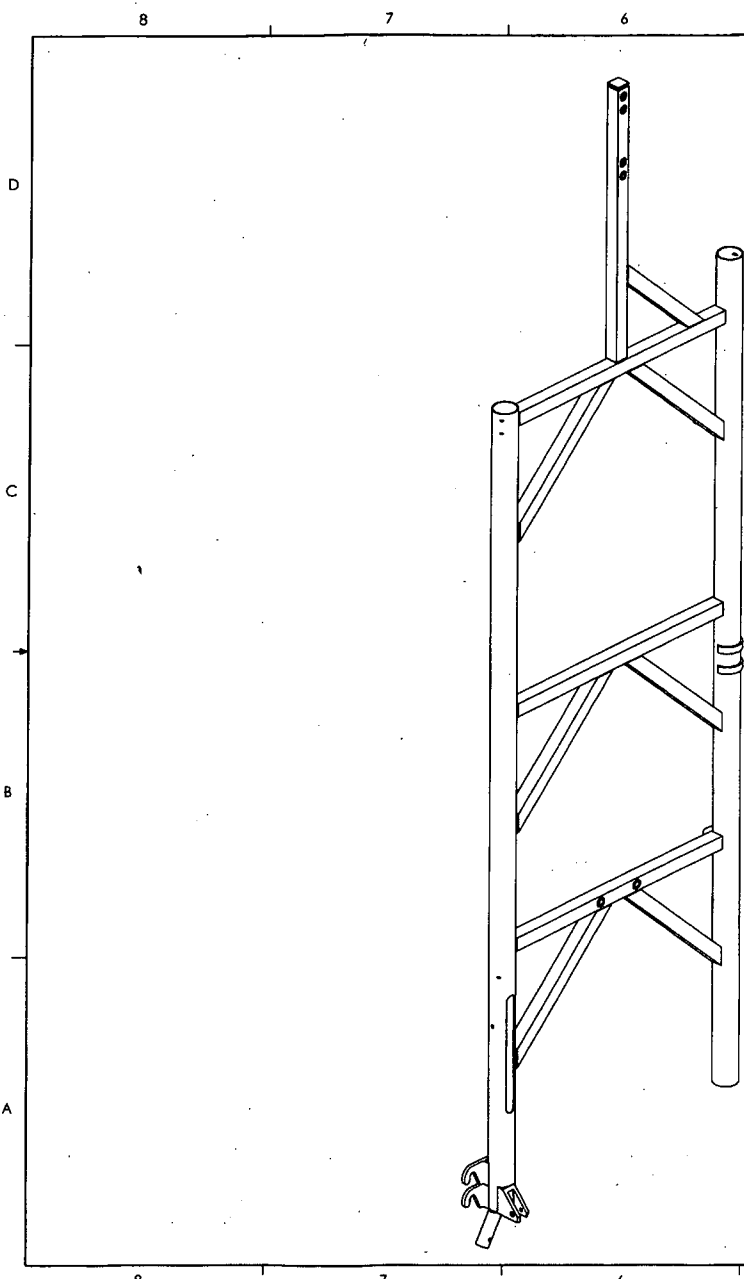
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____ _____ _____							
Misidentified ☐	Past Due ☐								



ITEM	QTY -09	P/N	DESCRIPTION
	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
1	2	B67-43001-201	SQUARE TUBE
2	1	B67-43001-203W	SQUARE TUBE WELDMENT
3	1	B67-43001-209	SQUARE TUBE
4	6	B67-43001-211	SQUARE TUBE
5	2	B67-43001-213	FLANGED HOOK
6	1	B67-43001-229W	OUTER TUBE WELDMENT
7	1	B67-43001-235	OUTER TUBE
8	1	B67-43001-239W	SQUARE TUBE WELDMENT
9	1	B67-43001-243	TUBE HANDLE EXTENSION
10	1	B67-43001-277	CONTOURED MALE EYE
11	2	B67-43001-311	RESTRAINT
12	1	D3440-9	TUBE DETENT CLIP BASE
13	1	D3440-13	BRACKET

RELEASED
2014-12-08

SH 7/12/16 148789

D	REVISE BOM AND ANNOTATIONS TO INCORPORATE -203W/-229W/-239W WELDMENTS. DELETE DETAIL C (SH 2, 3). REASON: TO FACILITATE MANUFACTURING	DB	14.07.24
C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043). FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING #B67-43001. REASON: SEE PAR#09-011	MB	10.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-09	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	14.07.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

MATE WITH TOP SURFACE OF
LOWER HOOK AND ALIGN WITH
CENTERLINE OF OUTER TUBE

ALIGN WITH BOTTOM
EDGE OF END CAP AND
CENTERLINE OF OUTER TUBE

ALIGN WITH CENTERLINE
OF OUTER TUBE AND FLUSH
WITH ANGLED CUT

B67-43001-243 [9]
TUBE HANDLE EXTENSION
REF

ALIGN WITH CENTERLINE OF
OUTER TUBE AND TO BOTTOM
SURFACE OF END CAP

D3440-13
BRACKET

DETAIL A D3-2
SCALE 4X

B67-43001-229W [D]
OUTER TUBE WELDMENT
REF

MASK INSIDE SURFACES
OF BRACKET PRIOR
TO POWDER COATING

B67-43001-243 [9]
TUBE HANDLE EXTENSION

B67-43001-213
FLANGED HOOK
2 PL

MASK INSIDE SURFACE
OF HOOK PRIOR TO
POWDER COATING
2 PL [9]

DETAIL E B3-2
SCALE 4X

MASK ALL AROUND TUBE
PRIOR TO POWDER COATING

B67-43001-311
RESTRAINT
2 PL

B67-43001-235
OUTER TUBE
REF

DETAIL B C5-2
SCALE 4X

[D] B67-43001-203W
SQUARE TUBE WELDMENT
REF

B67-43001-211
SQUARE TUBE
REF

[9]
2 PL

DETAIL D B4-2
SCALE 4X

[9] MASK INSIDE SURFACE AND
HOLE (NOT SHOWN) OF
CONTOURED MALE EYE
PRIOR TO POWDER COATING

D3440-9 TUBE DETENT CLIP BASE [9]
MASK THREADED HOLE (NOT SHOWN)
PRIOR TO POWDER COATING

DETAIL F C2-2
SCALE 4X

RELEASED
2014-12-08

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. B67-43001-09	REV. D
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		AFT BLADE FOLD ASSY WELDMENT	
DE APPR.	N/A	NTS	
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